

ship 28/08 - 31/08

SPUT

PK Page 1

Work Order ID 51549-1



August 25, 2009 2:01:30 PM

Item ID: DSI 9464-011

Revision ID: A

Item Name: Skidtube Tuning

Start Date: 8/26/09 Start Qty: 5.00

Required Date: 8/28/09 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: BS

QC:

Date: 09-8-25

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D3955 A

DSI 9464 A

100

0.00



DC

Document Control

Memo: *for BG 09/08/27*
Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

5 09/08/27

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

09/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 2:01:29 PM

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3955-041RevA 2P		Manufactured	No			110	Each	4.0000	10.0000 12			SP
------------------	--	--------------	----	--	--	-----	------	--------	------------	--	--	----



Doubler Assembly

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

FG

4

50862

4

110

Each

4.0000

10.0000 12



51555 4P

50862 4P

SP

D3955-3RevA 2P



Cover Plate

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

4

50865

4

110

Each

4.0000

10.0000 12



51552 4P

50865 4P

SP

D3955-5RevA 2P



Plate

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

4

50866

4

110

Each

0.0000

30.0000 36



51551 3P

50866 4P

SP

D3955-7RevA 6P



Plate

1351050 13P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning



Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S +2 D3955-21RevA 24 		Manufactured	No			110	Each	6.0000	10.0000 12 ✓			
Gasket												Peg 8/26 (6)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

50863

6

110

Each

2.0000

10.0000 12

51554 64
50863 6x

D3955-23RevA 20 		Manufactured	No			110	Each	2.0000	10.0000 12			
Template												Peg 8/26 (6)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

50864

2

110

Each

786.0000

190.0000 28 ✓

51553 70
50864 20

S fl CR3212-4-04 38x 		Purchased	No			110	Each	786.0000	190.0000 28 ✓			
Cherry Rivet												Peg 8/26 (6)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

786

109297

26

109740

16

110153

6

111127

238

112314

500

m111127 160x
m112314 68x

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A Bolt		Purchased	No			110	Each	2,515.000	20.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2515

100188

212

105057

2245

15205

58

110

Each

73.0000

20.0000

AN3-6A

Bolt

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

73

106662

22

107959

15

109752

29

112082

7

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

August 25, 2009 2:01:29 PM

Page 4

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00 6

Required Qty: 5.00 6

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-7A 4P

Purchased

No

110

Each

126.0000

20.0000

24 ✓



Bolt

PC 9/8/26 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

126

110704

26

111127

100

M116704

AN3-10A 4P

Purchased

No

110

Each

103.0000

20.0000

24 ✓



Bolt

PC 9/8/26 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

103

111119

100

17566

3

M111119 214

M17566 3P

NAS1149D0332J 6P

Purchased

No

110

Each

200.0000

30.0000

36 ✓



Washer

PC 9/8/26 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

200

110625

16

110844

184

M110844

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 5

Work Order ID: 51549

Parent Item: DSI 9464-011RevA

Parent Item Name: Skidtube Tuning

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 Nut		Purchased	No			110	Each	3,889.000	100000			

Warehouse Location

Loc Qty

Loc Code

Main Warehouse

ST	3889	
110844	32	
111274	365	
111668	992	
112314	2000	
112385	500	

111274

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 skidtubes in order to eliminate vibration. This kit consist of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201 (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:

The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. Plates must be installed symmetrically. The weight of individual plates are given in the Part List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.07.21
CERT. NO.: SH96-88
ISSUE NO.: 3

A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9464	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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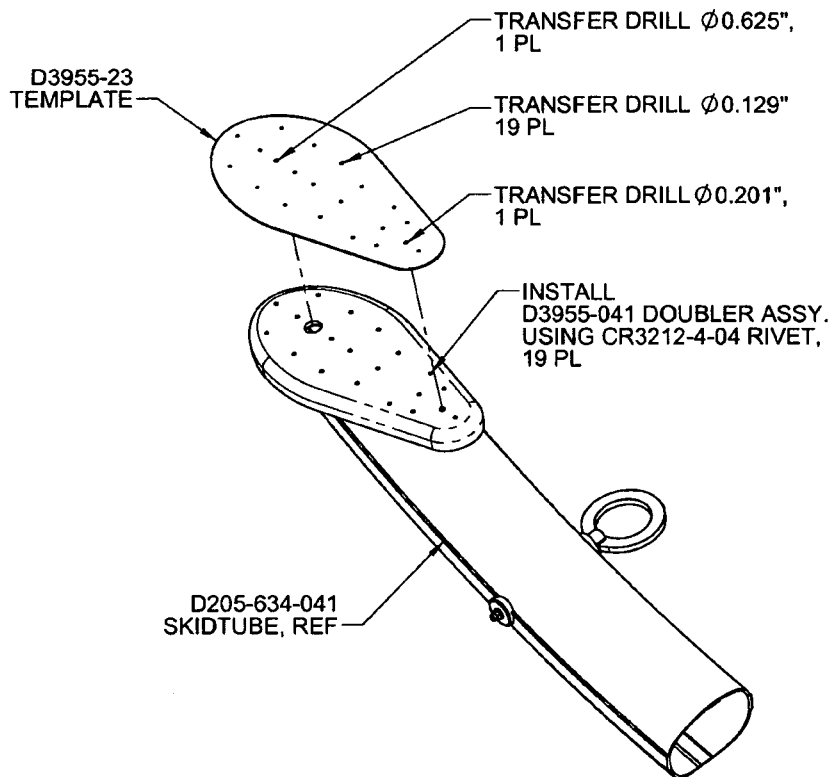


Figure 1

51549

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9464	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

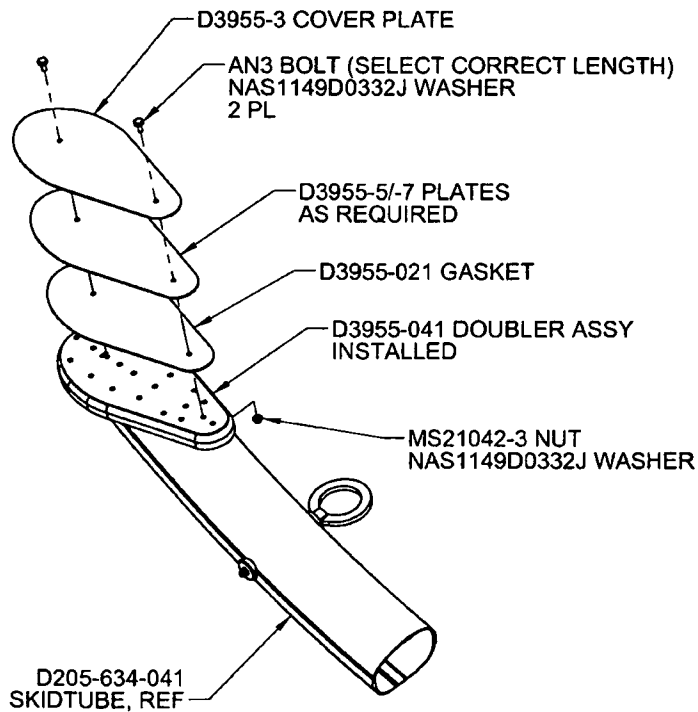


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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CERT. NO.: SH96-88
ISSUE NO.: 3

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5 /	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7 /	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

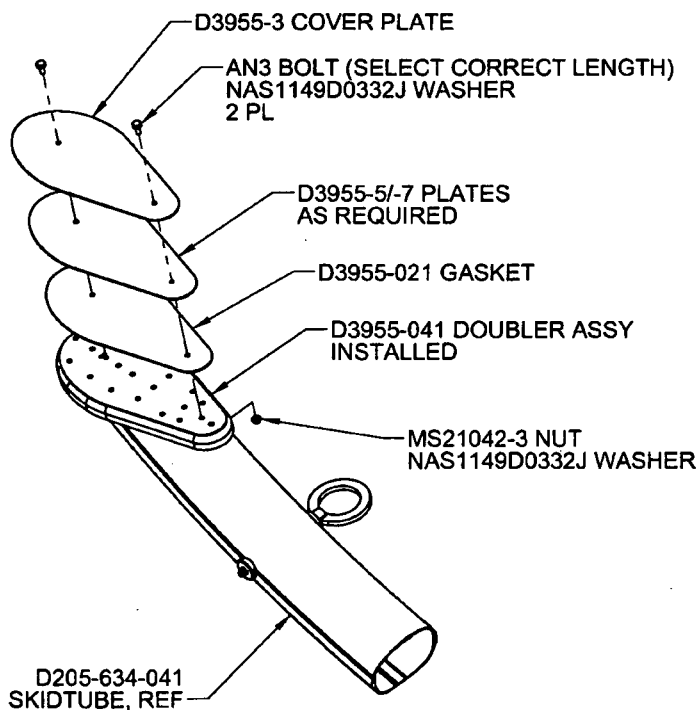


Figure 2

CANADA
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AIRCRAFT CERTIFICATION
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9464	SHEET 3 OF 3
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DE APPR.		SKIDTUBE TUNING KIT	NTS
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